

Work Order ID 64459

December 7, 2010 10:36:07 AM



Page 1

Item ID: D3247-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 12/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/12/07 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3247	Rev A
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100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .063

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB10-12-7



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB10-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:


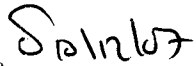

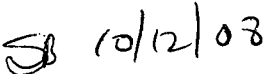


Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 12/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	=> M	1012109		8	0		
155 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M112588 Memo START TIME: 9:05 OVEN TEMP: 320° FINISH TIME: 9:35	0.00 0.00				8	BR	10-12-9	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> M	1012109		8	0		

Work Order ID 64459

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Item ID: D3247-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 12/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 180A

0.00



Packaging

Memo

0.00

Packaging

10/12/10 SP

80

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/10

U 10.12.10

Picklist Print

December 7, 2010 10:36:06 AM

Page 1

Work Order ID: 64459



Parent Item: D3247-1



Parent Item Name: Angle

Start Date: 12/06/10

Required Date: 12/13/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 04.10.26 D3247-1 no longer made in-house
10.12.06 NOW MADE IN HOUSE DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3247-1F

Purchased

No

110

Each

0.0000

6



13 10-12-7

Angle

113608



M 2024T3S.063

. 2347

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

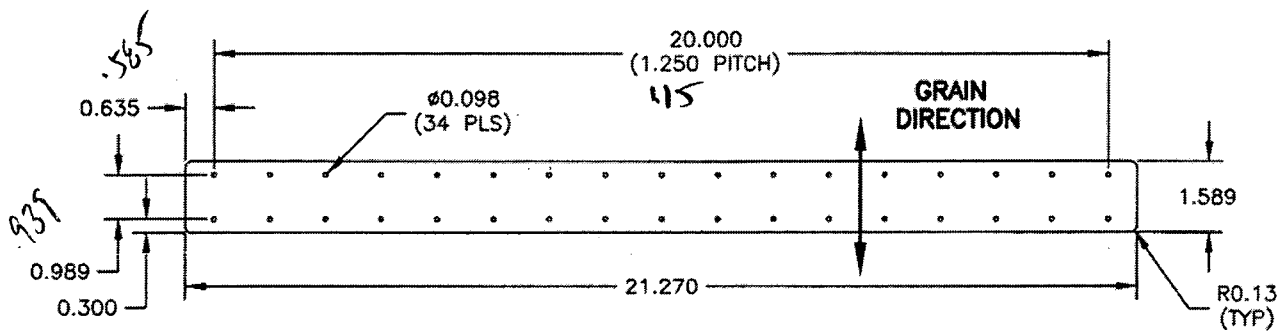
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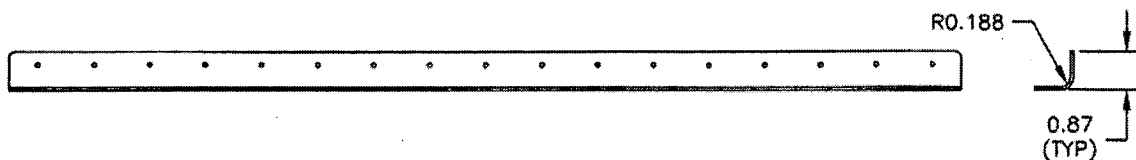


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED RT	DRAWING NO. D3247	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE ANGLE	SCALE 1:4
A	04.04.06	NEW ISSUE	

RELEASED
04.04.27



FLAT PATTERN



D3247-1 BEND DETAIL

#64459

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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